

Date: Wednesday, 03/06/2009 10:48:31 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEB ASSEMBLY
Job Number : 48349	
Estimate Number : 10194	
P.O. Number :	Part Number : D2174041
This Issue : 03/06/2009 S.O. No. :	Drawing Number : D2174 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : 37741	Material :
Written By :	Due Date : 20/06/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.06.03</u>	
Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM Est Rev:E As per Rev E 06-11-22 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D21741	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	B 48412 (10)

B 37848 (1)

2.0	D21751	Angle LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	B 31691

E 509/06/15

3.0	D21752	Angle RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	B 48413

E 509/06/15

4.0	MS20470AD46	Rivet, Universal Head
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Comment: Qty.: 19.0000 Each(s)/Unit Total : 152.0000 Each(s)
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	17110915

E 509/06/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:31 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 48349

Part Number: D2174041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:18pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

2:48pm

9/6/15

09-06-15

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD

09/06/15

(17)

9.0

AN526C832R14

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Screw

Batch:

M1D4916

9/6/15

SP

10.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Washer

Batch:

M110917

9/6/15

SP

11.0

MS21042L08

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Nut

Batch:

M111889

9/4/15

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:48:31 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 48349

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install nuts & bolts loosely as per Dwg D2274

09/06/16 (12)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/06/16 (12)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *100*

09/06/16

(12)

54

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16 (12)

Job Completion



MF
09-06-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

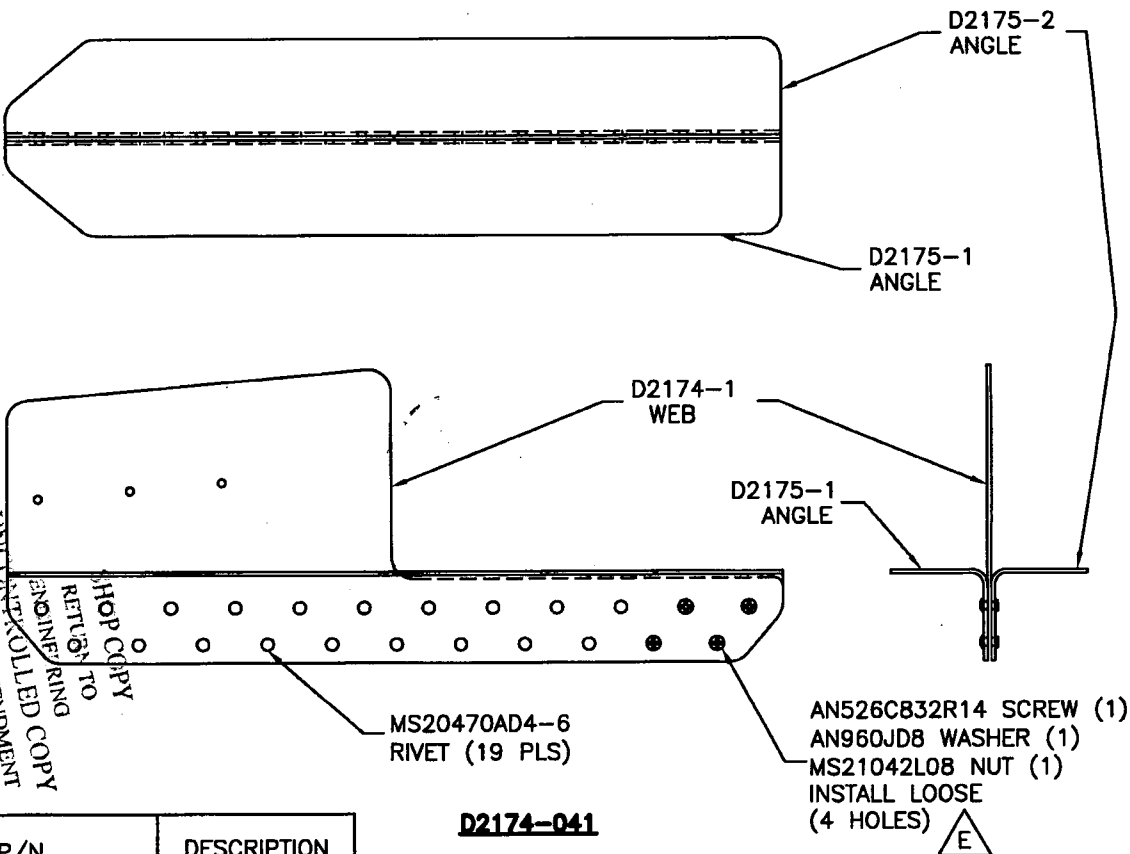
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA		REV. E
RF	CE	DRAWING NO.	D2174	SHEET 1 OF 2
CHECKED PH	APPROVED CH	DATE	06.09.25	SCALE 1:3
		TITLE	WEB ASSEMBLY	
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø.172; CHG HARDWARE		



QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

NO. 148318
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY

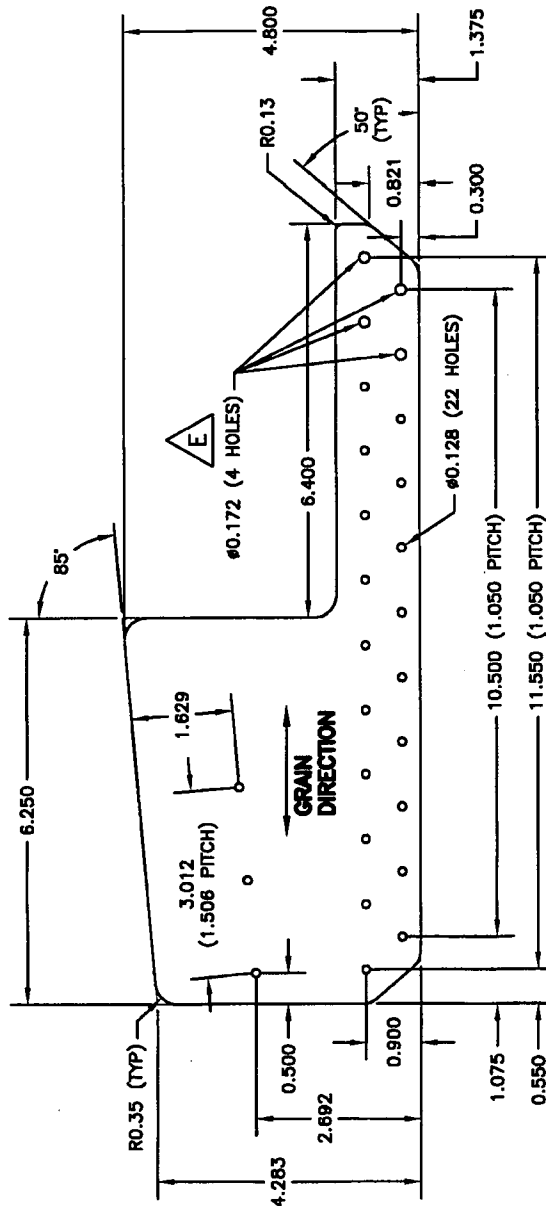
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RELEASED
06-10-13-14

DART

DESIGN RF	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2174	REV. E SHEET 2 OF 2
DATE 06.09.25	TITLE WEB		SCALE 1:3

RELEASED
06.10.23**D2174-1**

NOTES:
1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
98349

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